

Work Order ID 68214

Friday, April 08, 2011 11:51:04 AM



Page 1

Item ID:	D3067-1	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	End Plate					
Start Date:	4/8/2011	Start Qty:	100.00		Cust Item ID:	
Required Date:	4/12/2011	Req'd Qty:	100.00		Customer:	

Reference:

Approvals:	Process Plan:		Date:	11/04/8	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3067	Rev A

100:		0.00
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	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3067								
	Dwg Rev: A								
	Prog Rev: A								
	2-Deburr if necessary								

110	QC2- Inspect parts off machine FAI/FAIB	0.00
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QC	Memo	0.00							
Quality Control									

120	QC8- Inspect parts - second check	0.00
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QC	Memo	0.00							
Quality Control									

B11-4-11

(150)

B11-4-11

ml 11 04 11 (150)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 68214

Friday, April 08, 2011 11:51:04 AM



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Item ID: D3067-1

Accept



Setup Start



Revision ID:

Stop



Item Name: End Plate

Start Date: 4/8/2011 Start Qty: 100.00



Cust Item ID:

Required Date: 4/12/2011 Req'd Qty: 100.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Brake NC Brake NC	NC BRAKE Memo Bend as per Dwg D3067	0.00 0.00		SB 1164/11		<u>150</u>			
140 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		Subonly		<u>150</u>			
150 Packaging Packaging	Identify as per dwg & Stock Location: <u>WA</u> Memo *** STOCK IN STEP CELL ***	0.00 0.00		11.04.27		<u>150</u>	<u>φ</u>		

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Friday, April 08, 2011 11:51:04 AM



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Item ID: D3067-1

Accept



Setup Start



Revision ID:

Stop



Item Name: End Plate

Start Date: 4/8/2011 Start Qty: 100.00



Cust Item ID:

Required Date: 4/12/2011 Req'd Qty: 100.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/27 [Signature]
MF
11-4-27

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Friday, April 08, 2011 11:51:12 AM

Page 1

Work Order ID: 68214

Parent Item: D3067-1

Parent Item Name: End Plate



Start Date: 4/8/2011

Required Date: 4/12/2011

Start Qty: 100.00

Required Qty: 100.00

Comments: IPP: ☐ 03.01.21 Remove step 6 (Deburr) KJ
IPP Rev:B Now on Water jet 06-06-16 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M5052H32S.063

Purchased

No

100

sf

104.5000

0.0625

6.578947

10.



B11-4-11

5052-H32 .063 Sheet

Location

Loc Qty

Loc Code

MAT022

104.5

114322

104.5

114322

150

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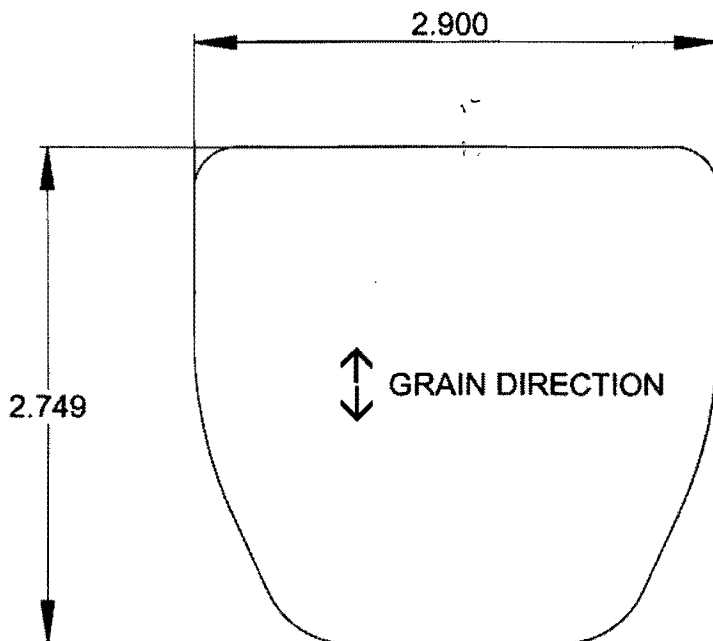
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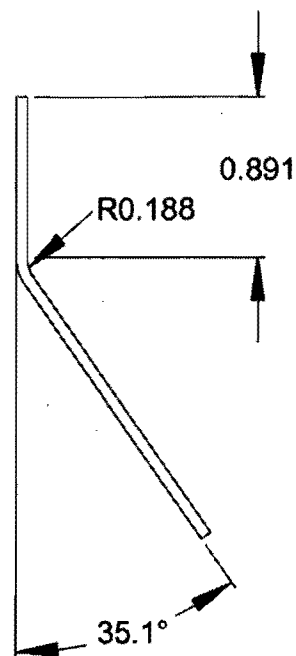


DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CP</i>	APPROVED <i>CP</i>	DRAWING NO. D3067	REV. A SHEET 1 OF 1
DATE 02.09.11		TITLE END PLATE	SCALE 1:1
A	02.09.11	NEW ISSUE	

RELEASED
02.09.2011



D3067-1 FLAT PATTERN



D3067-1 BEND DETAIL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 68217

PH-04-8

D3067-1 END PLATE

- 1) MACHINE PER DWG FILE "D3067-1.SLDPRT"
- 2) MATERIAL: 5052-H32 PER QQ-A-250/8 (REF DART SPEC. M5052H32S.063)
OR 6061-T6 PER QQ-A-250/11 (REF DART SPEC. M6061T6S.063)
ALUMINUM SHEET, 0.063 THICK
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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